

Work Order ID 60895

Monday, July 26, 2010 1:56:00 PM



Page 1

Item ID: D4149-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: HDate: 10-7-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

EP 10/08/23 (4)

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8.10.13.1

(X4)

120

0.00



Packaging

Identify as per dwg & Stock Location: 505

Memo

0.00

Packaging

10/11/31 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60895

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Page 2

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Required Date: 8/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31

CL 10/8/31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 1:56:04 PM

Page 1

Work Order ID: 60895

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft






Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5  Eyebolt Stud		Manufactured	No			100	Each	0.0000	1	4			
MS20615-4M18  Rivet		Purchased	No			100	Each	534.0000	3	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST323		534							
				114808		164							
				115037		370							
D3910-1  Crosstube Lug		Manufactured	No			100	Each	24.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st507		24							
				59349		23							
				59708		1							
D4091-1  Mounting Lug		Manufactured	No			100	Each	2.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST460		2							
				60239		2							
D4149-1  Crosstube Lug Plate, Aft		Manufactured	No			100	Each	0.0000	2	8			

B60790 (Bx)

B61234 (Bx)

EP 10/08/23

EP 10/08/23

EP 10/08/23

4

EP 10/08/23

B60874 (Bx)
B61008 (Bx)

B61009 (Bx)

EP 10/08/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 60895

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

D4149-3 Manufactured No

100

Each

0.0000

1

4



Spacer

AN3C12A



Bolts

Purchased No

100

Each

44.0000

4

16

B6087031

B61010



8/10/08/23

8/10/08/23

M115392

16

Location

Loc Qty

Loc Code

ST351

44

112314

8

114761

22

115016

14

AN4C13A



BOLT

Purchased No

100

Each

104.0000

1

4

Location

Loc Qty

Loc Code

ST357

104

113359

3

114108

1

114442

50

114615

50

MS21043-3



Nut

Purchased No

100

Each

2,985.000

4

16

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2909

107280

4

112314

2905

8/10/08/23

16

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 60895

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

MS21043-4 Purchased No 100 Each 1,220.000 1
Nut
4
8/10/08/23

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1180	
112492	25	
113069	8	
114348	347	4
114523	500	
114784	300	

NAS1149C0432R Purchased No 100 Each 724.0000 2
Washer
8
8/10/08/23

Location	Loc Qty	Loc Code
ST297	724	
114292	134	8
114742	590	

NAS1149C0332R Purchased No 100 Each 3,480.000 8
Washer
32
8/10/08/23

Location	Loc Qty	Loc Code
ST297	3480	
113524	10	
113737	150	
115000	3320	32

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Shop Packet Print

Page 3

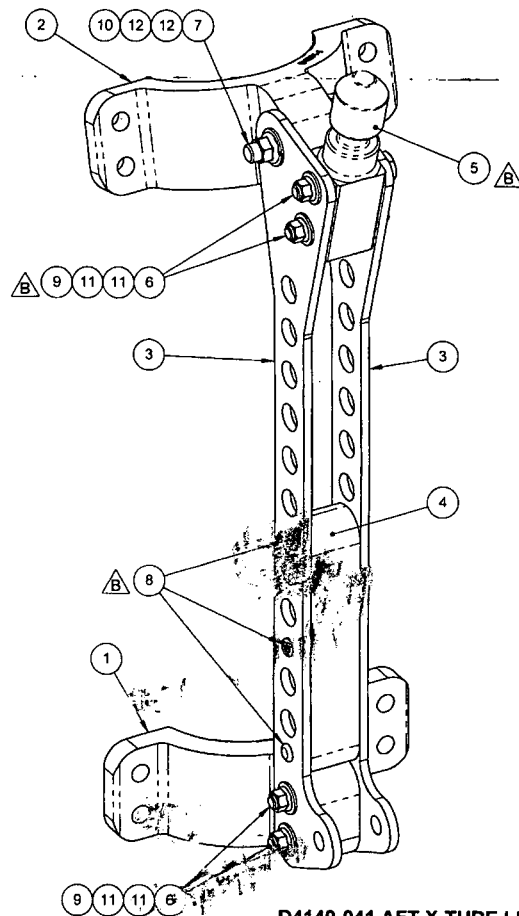
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.17 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60895
BS10-7-24

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	4	AN3C12A	
7	1	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	4	MS21043-3	NUT
10	1	MS21043-4	NUT
11	8	NAS1149C0332R	WASHER
12	2	NAS1149C0432R	WASHER

RELEASED
2010-07-16
MP

B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(5) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4149** REV. B
SHEET 1 OF 5
TITLE **AFT X-TUBE LUG ASSY** SCALE NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

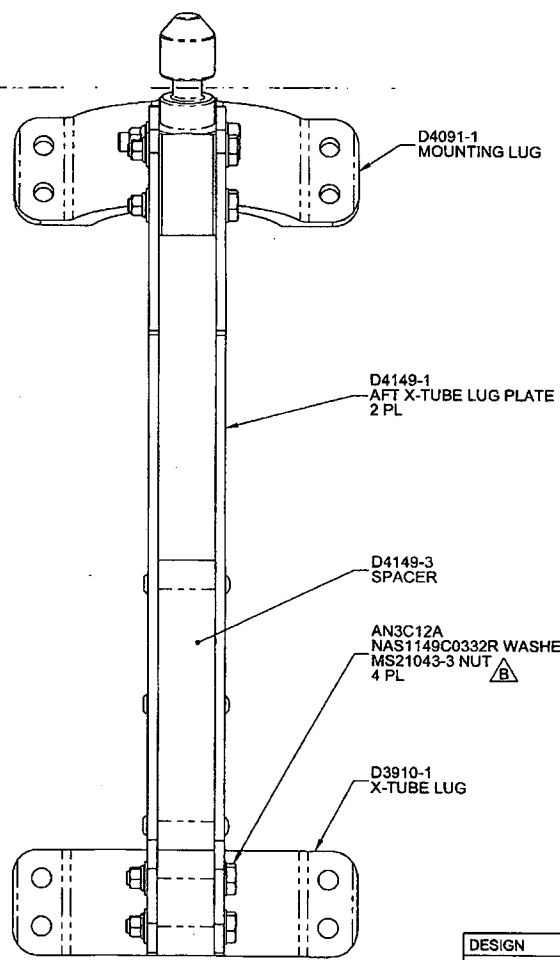
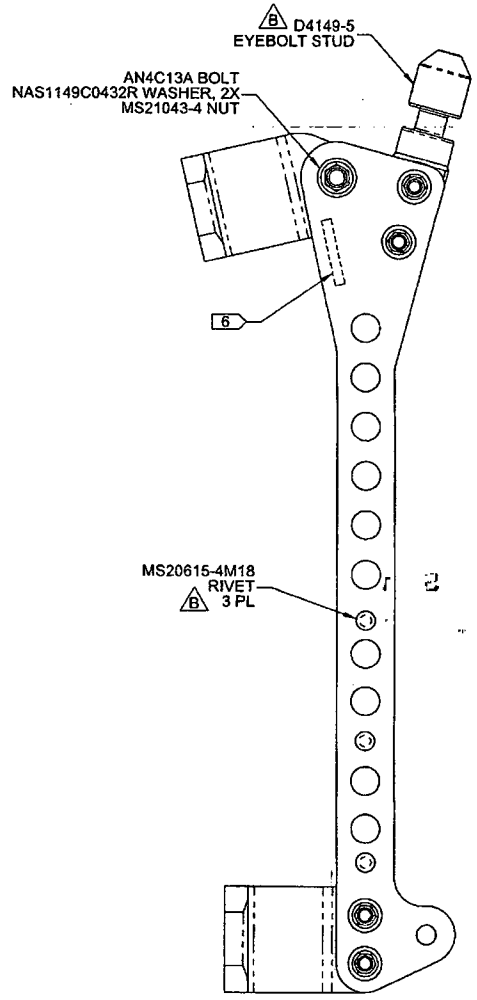
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A



W/O 60825

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2010-07-16
MP

D4149-041 AFT X-TUBE LUG ASSY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4149	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

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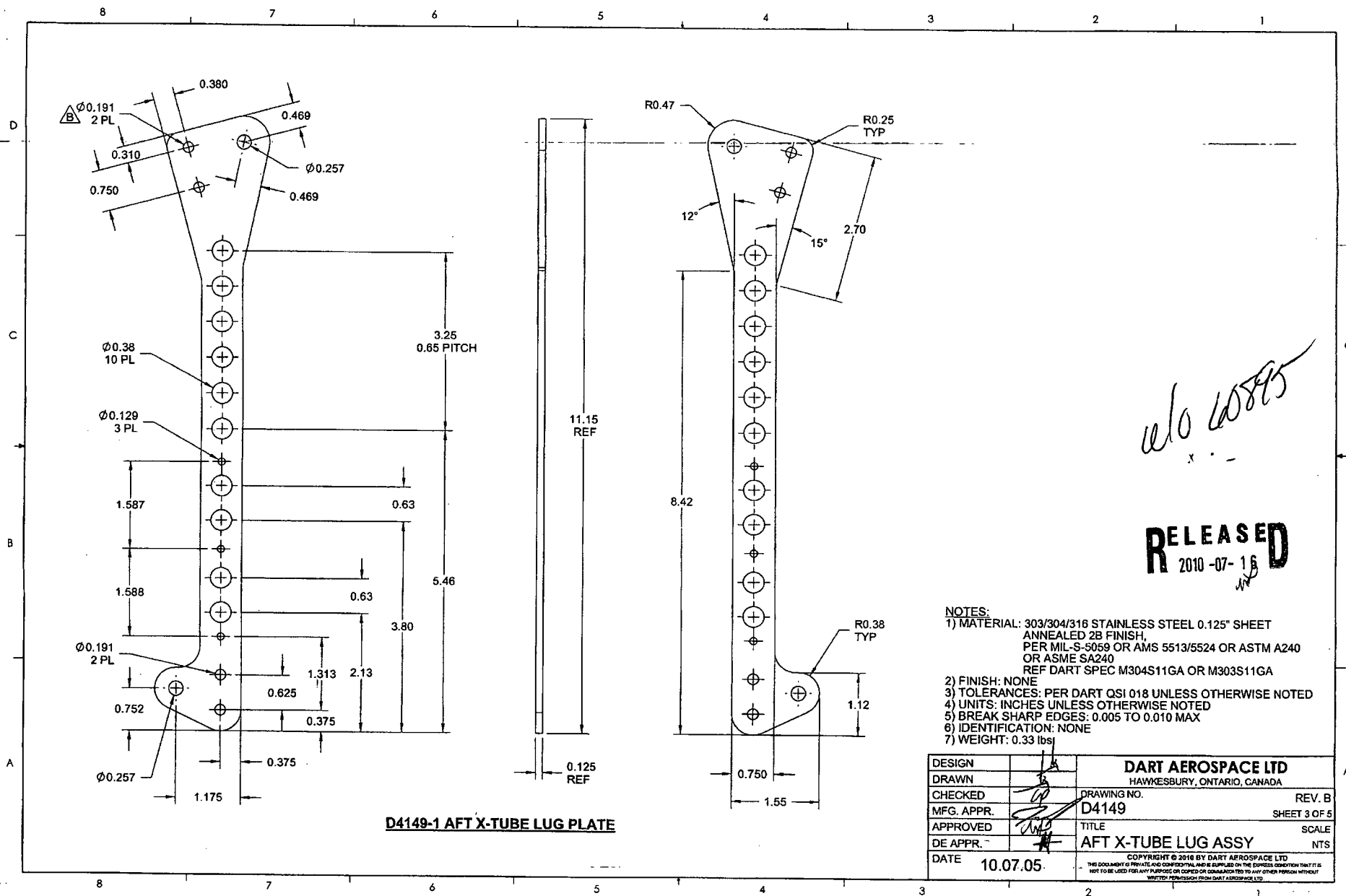
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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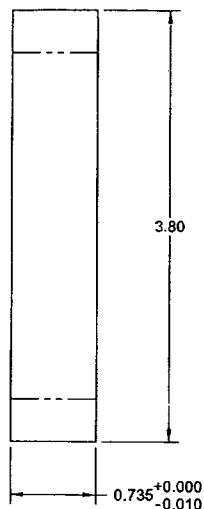
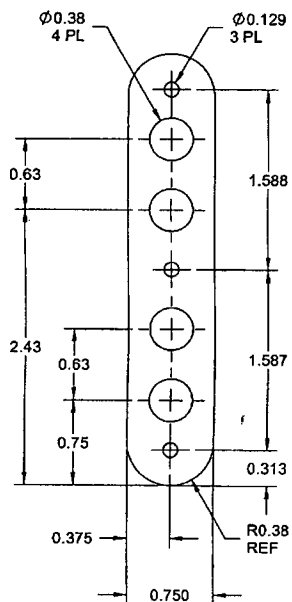
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

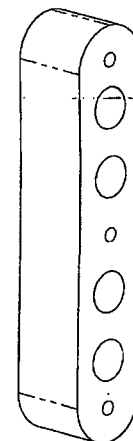
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4149-3 SPACER



w/o 60825

RELEASED
2010-07-16
JW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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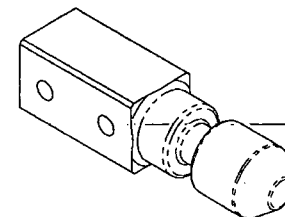
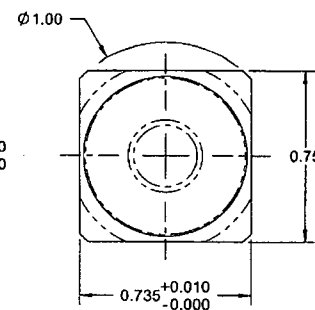
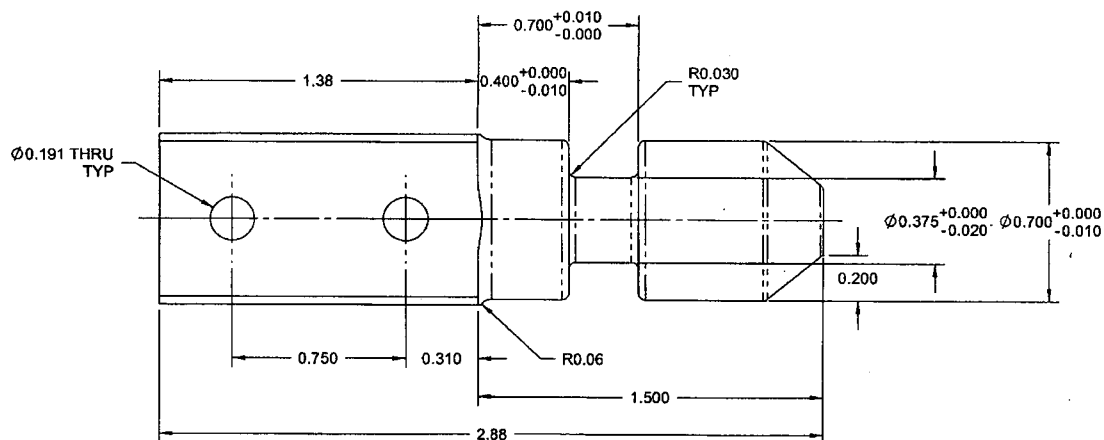
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NOTE: Date & initial all entries



D4149-5 EYEBOLT STUD

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4149	REV. B
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